

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022175**Date Inspected:** 14-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Bay 1**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of welding and heat straightening on Re-Built traveler rail assemblies. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Zhi Jiang as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20367

Weld- 20TR2-037-011

WPS-345-SMAW-1G(1F)-Repair

Welder-062810

1G/CJP/SMAW

Heat Straightening

HSR (B) 461

20TR2-036-009, 013, 015, 017, 011

Caltrans Stamped Approved

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### Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 8 ZPMC was in process of welding. ZPMC CWI inspector Fa Wen was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to them by ZPMC. This QA inspector verified this information for the following location;

Weld- SA7047-001  
WPS-B-T-2221-C-U2b-S-1  
Welder- 251393  
1G/SAW/CJP

Weld- SA7535-001  
WPS-B-T-2231-ESAB  
Welder- 054458  
1G/FCAW/CJP

### Bay 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 11 ZPMC was in process of heat straightening traveler rail 20TR2-034-009, 013, 015, 017, 011 and 20TR2-035-009, 013, 015, 017, 011 in accordance with HSR1 (B) 10131. ZPMC QC inspector Shao Hai Lang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhao Chen Sun as the CWI.

### UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08546 from ZPMC for Bay 11. This QA inspector performed ultrasonic test (UT) verification for Item 1, 3, 4, 16, 17 after ZPMC had performed their UT inspection of the following locations.

Item 1  
25TR1-001, 012  
Item 3  
25TR2-001, 012  
Item 4  
30TR1-001, 012  
Item 16  
25TR1-003, 005, 014, 015  
Item 17  
34TR1-004, 005, 015, 016

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 03-14-2011 for additional information.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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